Work Order ID 59488

Friday, June 04, 2010 2:49:26 PM

110

Quality Control



Page 1

B 10-6-10

Item ID: D4008-041 Accept Setup Start **Revision ID:** Item Name: Fuel Filler Splash Guard Assembly Stop **Start Date:** 6/4/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/10/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start Date 607 **Approvals: Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp **Draw Nbr Revision Nbr** D4008 Α 100 0.00 1810-6-10 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg (D4008-1) Dwg Rev: 6061 .032 Prog Rev: 2-Deburr if necessary

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

										L
W/O:			WC	RK ORDER CHANG	ES		 			
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							.			
<u>.</u>										
Part No		PAR #:	Fault Cate	gory:	_ NCR: Ye	es No	DQ	A:	_ Date: _	
Resolution:			Disposition: (ed:	 _	Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Initial Action Description				Verification		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		n & ate	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 59488

Friday, June 04, 2010 2:49:26 PM



Page 2

Item ID:

D4008-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/10/2010

Fuel Filler Splash Guard Assembly

Start Date:

6/4/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Memo

Set Up/ **Run Hours**

0.00

Siolochio

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

Bend as per dwg

0.00

0.00

Se woode

140

Quality Control

QC5- Inspect part completeness to step on W/O

Bend D4004-1 as per Dwg

0.00

Sistoutio

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector								
								1						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA :	Date: _							
		solution: Disposition:			_ QA: N/C Cld	Date: _								
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCR)								
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval						
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector						
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Work Order ID 59488

Required Date: 6/10/2010

Friday, June 04, 2010 2:49:26 PM



Page 3

Item ID:

D4008-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fuel Filler Splash Guard Assembly

Start Date:

6/4/2010

QC:

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Process Plan:

Date:_____

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

150-

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Hand Finishing

160

Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

REMOVE PIN PRIOR TO POWDERCOATING

Start Time: 7:15AM Oven Temperature: 3200/= Finish Time: 7:454 ~

170

Quality Control

QC3- Inspect Part Finish

Memo

0.00

1 St 10-6-11

0.00

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cated	iorv.	NCR: Yes	No DOA	\ <u> </u>	Date:	
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NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	R)			
DATE	STED	Description of NC			Section B Ve		ation	Approval	Approval
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng			on C	Chief Eng	QC Inspector
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Work Order ID 59488

Friday, June 04, 2010 2:49:26 PM



Page 4

Item ID:

D4008-041

Accept

Setup Start



Revision ID:

Item Name:

Fuel Filler Splash Guard Assembly

Start Date:

6/4/2010

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:____

Tooling:

Date:

Tool ID

Run

Start

Stop



Required Date: 6/10/2010

Date: _____ SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Number Stamp

Insp.

Reject

Sequence ID/

Work Center ID

180

Small Fab Small Fab

Memo

Memo

Assemble as per dwg

Set Up/ **Run Hours**

0.00

0.00

Reject

Qty

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

5 rolle

Accept

Qty

200

Identify as per dwg & Stock Location:

0.00

Memo

0.00

Packaging

Packaging

	-									•
W/O:			WC	RK ORDER CHANG	ES					
DATE STEP		PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ /	A :	Date: _	
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NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector

Work Order ID 59488

Friday, June 04, 2010 2:49:26 PM



Page 5

Item ID:

D4008-041

Accept

Setup Start



Revision ID:

Item Name:

Fuel Filler Splash Guard Assembly

Start Date:

6/4/2010

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID: Customer:

Reference:

A	nr	ro	val	٠.
α	w	u v	V 201	

Process Plan:

Operation

Description

Date:_____

Tooling:

Date:

Start

Stop



Required Date: 6/10/2010

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ Work Center ID

210

Memo

QC21- Final Inspection - Work Order Release

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Run

Reject Number

Insp. Stamp

Quality Control

0.00

0.00

mt 10-11-14

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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		PAR #:	Fault Cat	egory:	_ NCR: Yes	: Yes No DQA : Date :								
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Picklist Print

Friday, June 04, 2010 2:49:30 PM

Work Order ID: 59488

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Comments:

Parent Item:

IPP rev A 10.01.27 New issue Prelim EC verified by:DD

Manufactured

Manufactured

No

No

Start Oty: 1.00

Start Date: 6/4/2010

Required Date: 6/10/2010

Page 1

Required Oty: 1.00

1	0.05.03 as per ECN	N10-562 DD ver	ified by	:EC				`	Juni		require	u Qiy. 1.0	O
Component Item ID/ Item Name M6061T6S.032	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure sf	Qty on Hand 69.7000	Qty per Kit 0.2735	Total Otv 0.287895	Qty Issued	Date Issued	Status
6061-T6 Sheet 0.032"											B10-	6-10	
				Location		<u>Loc</u>	<u>Oty</u>	Loc Code					
				MAT21		•	69.7						
					110063		3				/		
					112763		52.7		il	12763	C	ソ	
					16954		8		-				
					18375		6		_				
D4008-5		Manufactured	No			180	Each	1.0000	1	1/2			

IPP Rev:B

Fuel Filler Splash Guard Hinge Half

Location	Loc	Loc Code	
ENG		1	
55873		1	
	180	Each	27.0000

D4008-9

Spring

Location	Loc Qty	Loc Code	E		
ENG	27	7			
55193	27				
	180 F	Each 5,0000			

D4008-7

Washer

<u>Location</u>	Loc Qty	Loc Code
ENG	5	
55874	5	

W/O:		WORK ORDER CHANGES												
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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		PAR #:	Fault Category: NCR: Yes No I											
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Friday, June 04, 2010 2:49:30 PM

Work Order ID: 59488

Parent Item:

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments:	IPP rev A 10.01.2 10.05.03 as per EC	7 New issue P N10-562 DD v	relim EC verified by	C verified by y:EC	:DD IPP I	Rev:B		S	Start Qty: 1.00)	Require	ed Qty: 1.0	00
Component Item ID/ Item Name MS20470AD3-3	Replacement Item ID	Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID 180	Unit of Measure Each	Qty on Hand 8,543.000		Total Otv	Qty Issued	Date Issued	Status
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MS35206-S245		Purchased	No			180	Each	100.0000	2	20	-		
Screw										4	0/1	1/02	ζ
				Location		Loc (Qty	Loc Code	,				
				ST294			100						
					113898		100			2	-		
NAS1149DN832J WASHER		Purchased	No			180	Each	434.0000	6	6/	500/1	1/00	2
										//		•	

Loc Oty

434

434

Loc Code

Location

114740

ST298

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC,Inspector
		181011							
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Picklist Print

Friday, June 04, 2010 2:49:30 PM

Page 3

Work Order ID: 59488

Parent Item:

D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly

Comments:

IPP rev A 10.01.27 New issue Prelim EC verified by:DD

10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Required Date: 6/10/2010

Start Date: 6/4/2010 Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3941

Replacement Mfg/ Item ID Purch

Bin Item Location Manufactured No

Primary

Last Location

Route Seq ID 180

Unit of Qty on Measure

Hand 65.0000

Loc Code

Qty per Kit Total

Issued Otv 0.221053

Oty

Date Status Issued

0.21

Rubber Cushion

Location

ST408

48512

Loc Qty 65

65

cut 1.25" long

	•									
W/O:			WC	ORK ORDER CHANG	SES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ /	A :	Date:	
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DATE	STEP	Description of NC		Corrective Action Section B				ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	59488
Description: FUEL FILLER SplasH GUARA ASSEMBLY	Part Number:	D4008-041
Inspection Dwg: D4008-(Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by:	VP	Audited by:	Prototype Approval:	N/A
	10-6-10	Date: 10/06/10	Date:	N/A

Г	—	D-4-	Change	Revised by	Approved
ļ	Rev	Date		KJ/JLM	٠.
	Α		New Issue		

SHOP COPY RETURN TO **ENGINEERING**

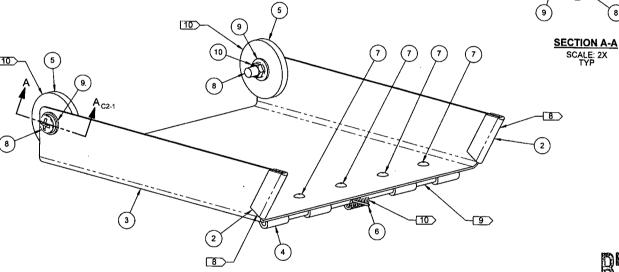
QTY. -041 ITEM NO JOHN CAMERON AVIATION PART NUMBER PART NUMBER DESCRIPTION x D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY JCA-M47-2-26 2 2 D3941-1 RUBBER CUSHION 3 1 D4008-1 FUEL FILLER SPLASH GUARD CHANNEL 4 1 D4008-5 HINGE 5 2 D4008-7 WASHER 6 1 D4008-9 SPRING 7 5 MS20470AD3-3 RIVET 8 2 MS35206S245 SCREW 9 6 NAS1149DN832J WASHER 10 2 MS21042L08 NUT

UNCONTROLLED CO12/ SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER NO. 59488

B6-1

D



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.15 lbc

7) WEIGHT: 0.15 lbs

7) WEIGHT: 0.75 IDS 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT 9) MASK HINGE PIN AREA BEFORE POWDER COAT 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

A	NEW ISS	SUE		1	10.02.05
REV.			DESCRIPTION	BY	DATE
DESIG			DART AER	OSPACE L	
	HECKED B		DRAWING NO.	ONTANIO, CANA	REV. A
MFG. A	APPR.	色	D4008		SHEET 1 OF 10
APPRO	OVED	10	TITLE		SCALE
DE API	PR.		SPLASH GUARE)	NTS
DATE 10.02.05			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS IMPLIED ON THE EXPRESS DOTION THAT IT IS NOTTO BE USED FOR ANY PROPESSE OF CONFIDENCE TO ANY OTHER PERSON WITHOUT		

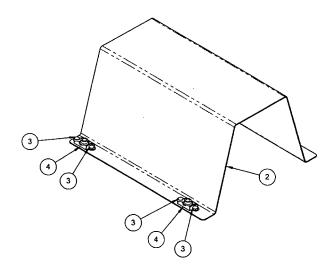
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	\:	Date:	
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NCR:			WORK ORD	PER NON-CONFORMA	NCE (NCR	3)			
DATE	CTED	Description of NC	Corrective Action Section			Verific	ation	Approval	Approval
DATE	SIEF	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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			6 5	, 4
ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	х	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
	<u></u>			
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	8	MS20426AD3-3	RIVET	· · · · · · · · · · · · · · · · · · ·
4	4	MS21059L08	NUT PLATE	T
			NUTPLATE	



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

wlo 39488

С

С

NOTES:
1) MATÈRIAL:
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.46 lbs

DESIGN	45	DART AEROSPAC	FITD	
DRAWN	3 5	HAWKESBURY, ONTARIO.		
CHECKED	B	DRAWING NO.	REV. A	
MFG. APPR.	E	D4008	SHEET 2 OF 10	
APPROVED	10	TITLE	SCALE	
DE APPR.	-#	SPLASH GUARD	NTS	
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDED THIN AND IS SUPPLIED ON THE STRIKES CONTINUE THIS HOT TO BE USED YOU ARE THE PURPLIES ON CORPER OF COMMANDED TO DART OTHER PERSON WITHOUT		

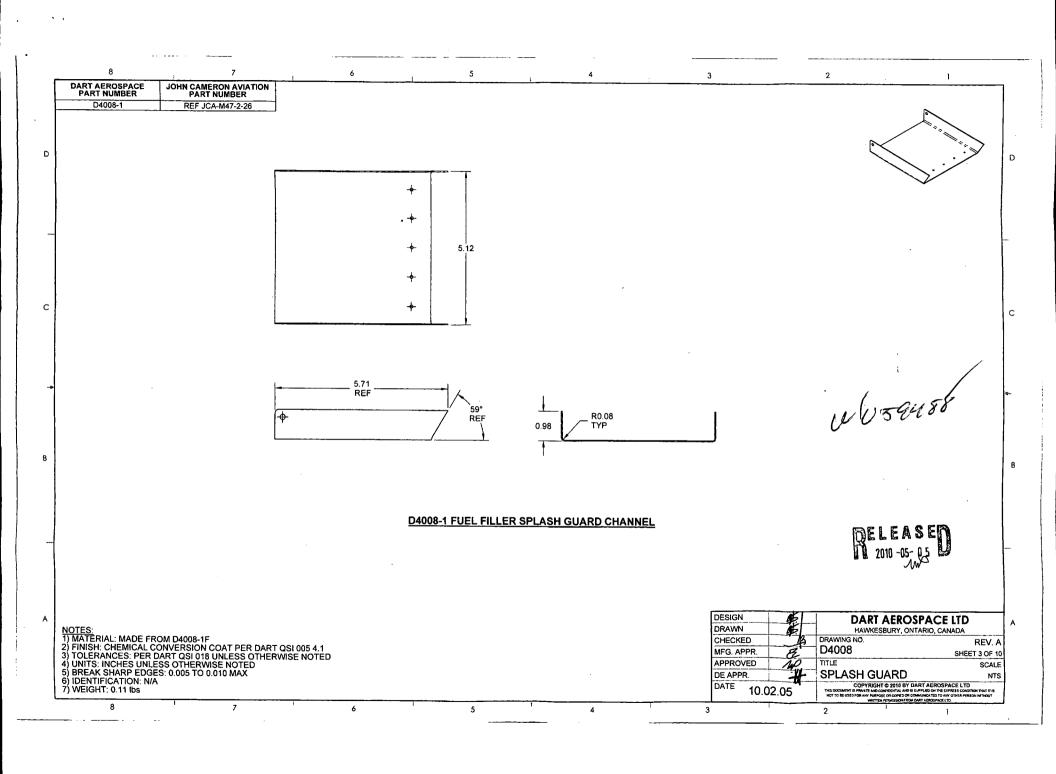
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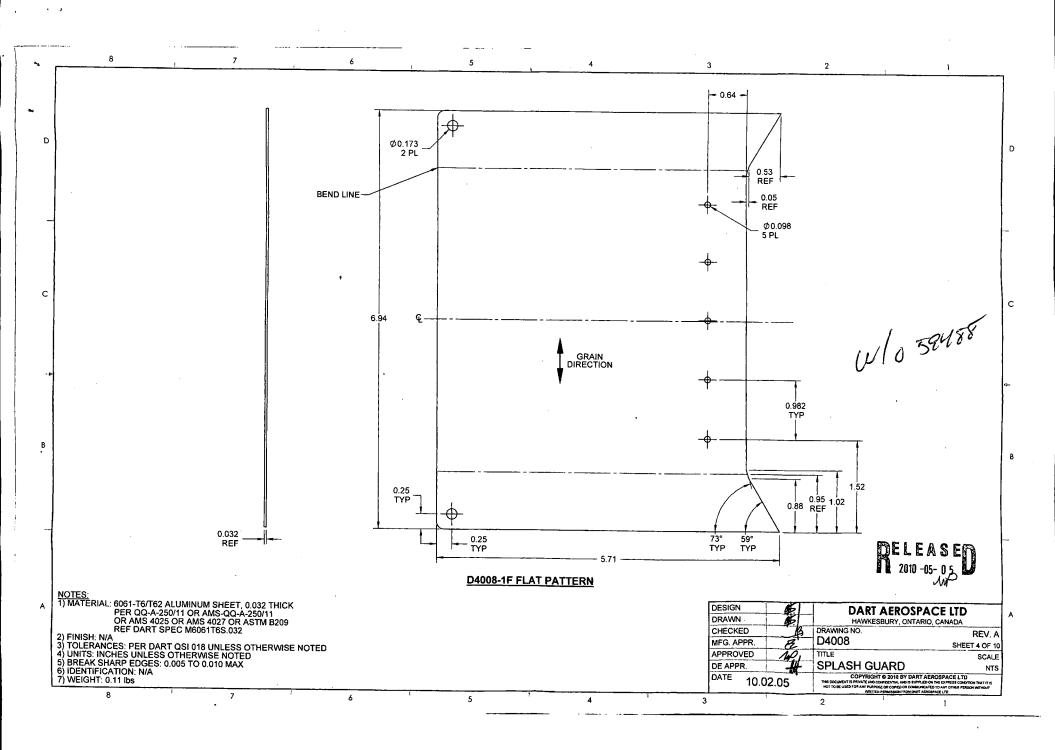
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DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Ye	es No	DQA:	Date: _	
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DATE	STEP	Description of NC		Corrective Action Section			Verification	Approval	Approval
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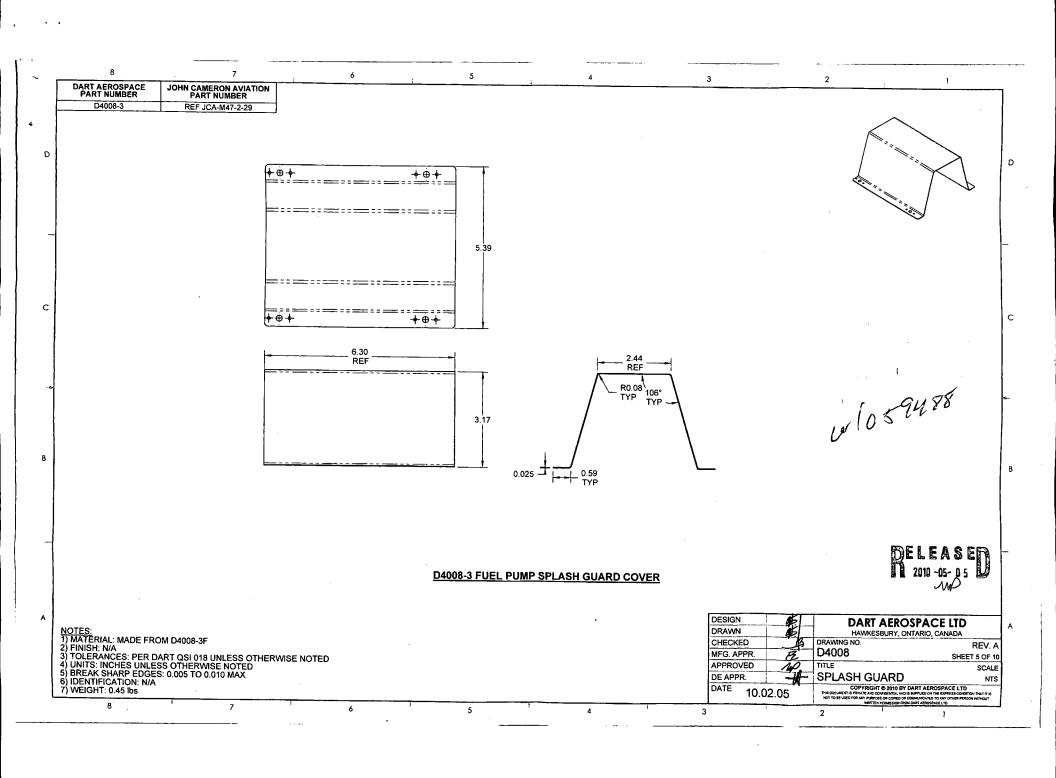
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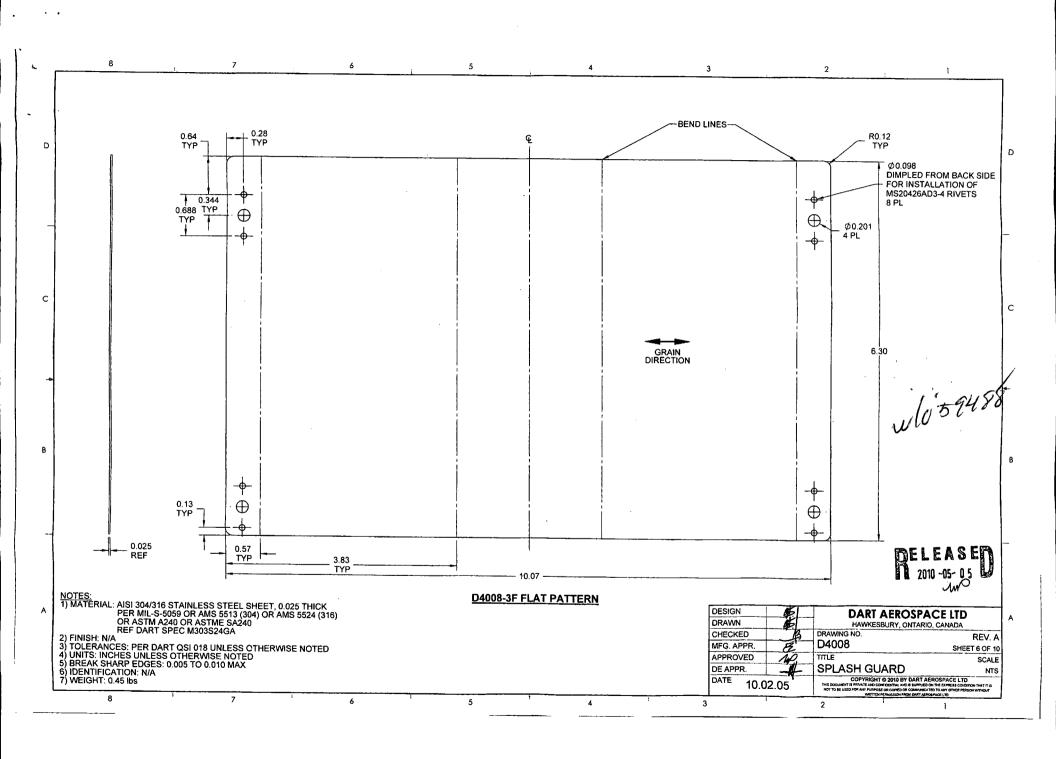
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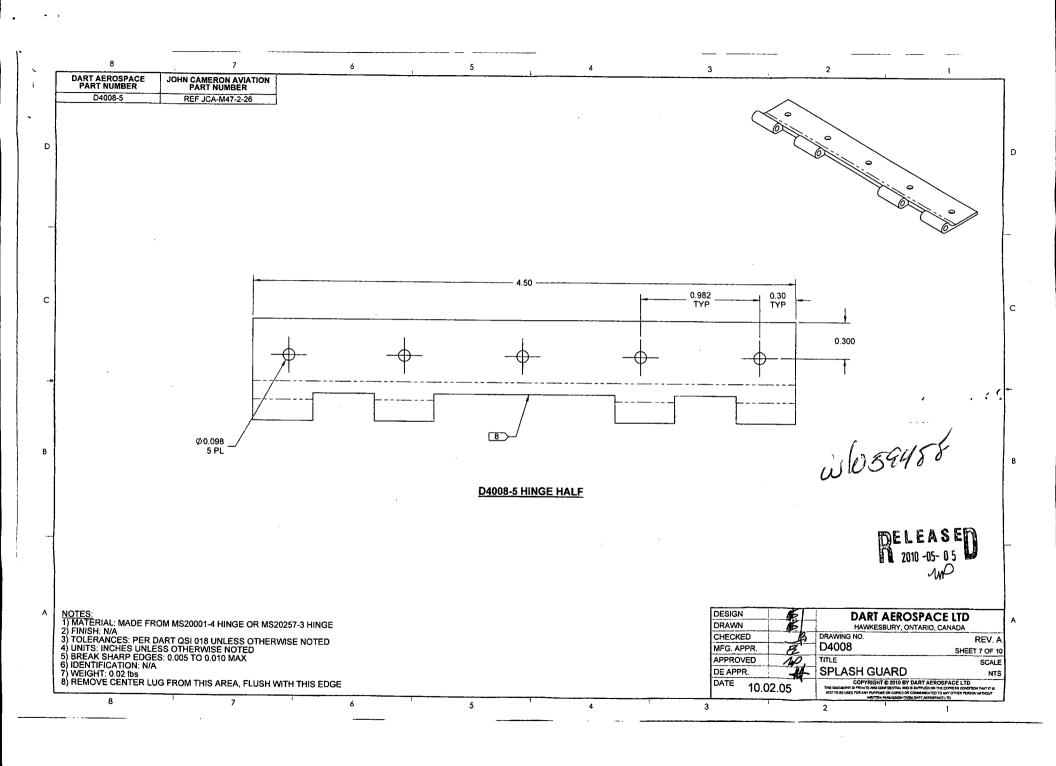
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Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ	A:	Date:	
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NCR:		,	WORK ORDI	ER NON-CONFORM	MANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ection B	Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
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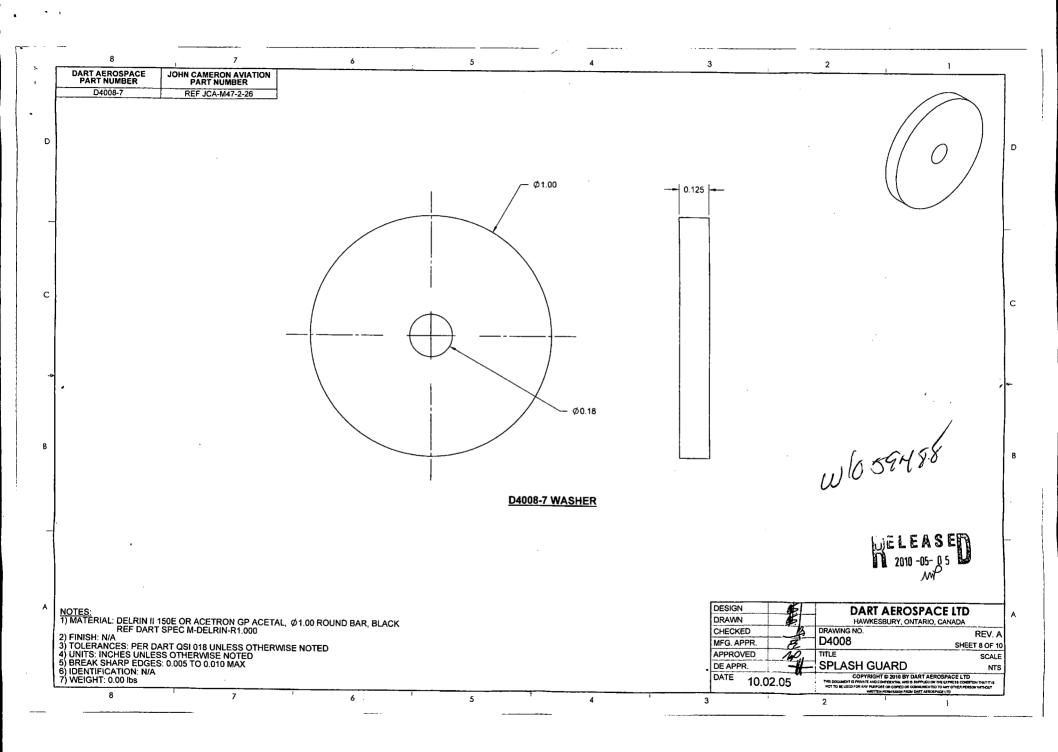
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DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
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DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:	
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	?)			· - 24
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
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DATE	STEP	Description of NC)	Corrective Action Section		Verific	cation	Approval	Approval
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4008-9 REF JCA-M47-2-26

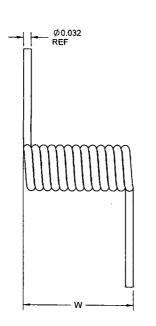
SPECIFICATION CONTROL DRAWING

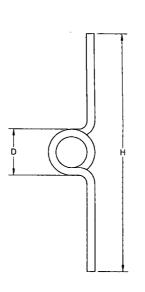


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DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

NOTES:	
NOTES: 1) MATERIAL: T301 OR 304 STAINLESS STEEL SP 2) SINGLAMA	PRING WIRE Ø0.032 PER ASTM A313

2) FINISH: NIA

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 lbs

DESIGN	4	DART AEROSPA	CE LTD
DRAWN	45	HAWKESBURY, ONTARIO	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	B	D4008	SHEET 9 OF 10
APPROVED	140.0	TITLE	SCALE
DE APPR.	-#	SPLASH GUARD	NTS
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AS THIS DOCUMENT IS PRIVATE AND CONSTIDENTIAL AND IS SUPPLIED ON MOT TO BE USED FOR MAY PURPOSE OR DOPED OR COMMUNICAT MOTITUDE PRIVATION FRANCISCO AND	ON THE EXPRESS CONDITION THAT IT IS TO TO ANY OTHER PERSON WITHOUT

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DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr QC Inspect Chief Eng/Prod Mgr QC Insp	W/O:
Part No:	DATE STEP
	Part No:
Resolution: Disposition: QA: N/C Closed: Date:	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	NCR:
DATE STEP Description of NC Corrective Action Section B Verification Approval Approval Approval	DATE STED
Section A Initial Action Description Sign & Section C Chief Eng Ch	DATE SIEP
	:

3 2 D С 0.51 TYP w/0 59488 **D4008-11 TANK HINGE HALF** DESIGN NOTES:
1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
2) FINISH: N/A
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: STOCK AS D4008-11
7) WEIGHT: 0.02 lbs DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4008 MFG. APPR. SHEET 10 OF 10 APPROVED TITLE SCALE SPLASH GUARD DE APPR. NTS

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Dart Aerosp	pace Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	_ NCF	NCR: Yes No DQA: Date:					
	Re	esolution:	Disposition	QA:	N/C CI	sed:		Date:		
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verific	ation	Approval	Approval
			Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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